

Work Order ID 57017

March 17, 2010 7:15:54 AM

Page 1

Item ID: D3240-1

Revision ID:

Item Name: Frame

Start Date: 3/17/10 Start Qty: 6.00

Required Date: 3/18/10 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3240

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3240
Deburr if necessary

Dwg Rev: *B*

Prog Rev: *B* 12-

B 10-3-18

(6)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B 10-3-18

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

Solovis

(x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3240-1

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Start Date: 3/17/10

Start Qty: 6.00

Required Date: 3/18/10

Req'd Qty: 6.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary

0.00

0.00

N/A

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

*7/2/10 10/03/19**(X6) Ø*

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

Rec'd 3/19 (6)

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Item ID: D3240-1

Revision ID:

Item Name: Frame

Start Date: 3/17/10

Start Qty: 6.00

Required Date: 3/18/10

Req'd Qty: 6.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Packaging

Identify as per dwg & Stock Location: 217

0.00

Memo

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CY1013119

1003-19

Picklist Print

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Page 1

Work Order ID: 57017



Parent Item: D3240-1



Parent Item Name: Frame

Start Date: 3/17/10

Required Date: 3/18/10

Comments: IPP B 05.04.28 Added Step 6 & 7 KJ/JLM
IPP Rev C now water jet 07-11-01 DD

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M2024T3S.063



2024-T3 .063 sheet

16.0042



B10-3-18

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111.0801505

105916

1.09

110980

5.4854

111787

0.00475051

113866

69.3

113867

33.2

19059

2

113866

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

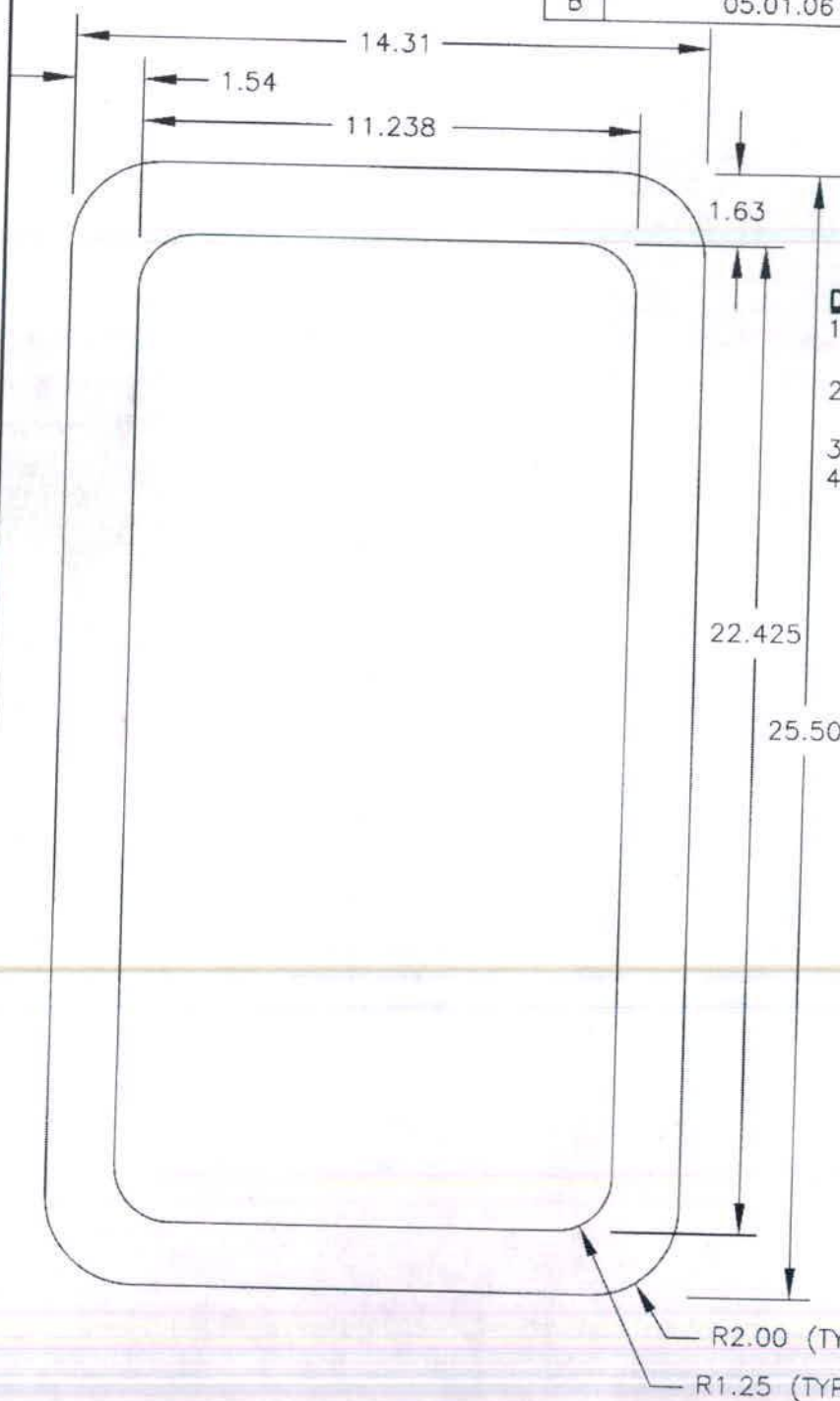
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3240	REV. B SHEET 1 OF 1
DATE 05.01.06		TITLE FRAME	SCALE NTS
A	03.12.18	NEW ISSUE	
B	05.01.06	25.50 WAS 25.19; 14.31 WAS 14.19	



RELEASED
05-02-02 *HA*

D3240-1 FRAME

- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.063 THICK (REF. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WLO
57017

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